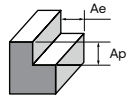


Recommended Cutting Data



Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



NiTiCo 30 DH 2xD Standard Internal Oil Hole, Weldon, Recess, 5 Flutes - K65

Side Milling	K		P		M		S							
Working Material	Grey Cast Iron		Carbon Steel		Alloy Steel		Stainless Steel		Titanium Alloy		Nickel Alloy		Cobalt Alloy	
Properties	-		-		520 < Rm < 1200		High Machinability		-		-		-	
Cutting depth, ap	1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, ae	0.25 × D		0.25 × D		0.20 × D		0.18 × D		0.15 × D		0.15 × D		0.15 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	280	0.016	310	0.017	250	0.019	180	0.021	100	0.025	50	0.025	40	0.023
5		0.021		0.022		0.025		0.027		0.032		0.032		0.030
6		0.025		0.027		0.031		0.033		0.039		0.039		0.037
8		0.035		0.036		0.043		0.045		0.054		0.054		0.051
10		0.045		0.046		0.055		0.057		0.069		0.069		0.065
12		0.056		0.056		0.069		0.071		0.087		0.087		0.082
16		0.071		0.072		0.087		0.089		0.108		0.108		0.103
20		0.084		0.088		0.107		0.109		0.128		0.128		0.122



NiTiCo 30 DH 2xD Standard Internal Oil Hole, Weldon, Recess, 5 Flutes - K65

Trochoidal Milling	K		P		M		S							
Working Material	Grey Cast Iron		Carbon Steel		Alloy Steel		Stainless Steel		Titanium Alloy		Nickel Alloy		Cobalt Alloy	
Proprietà	-		-		520 < Rm < 1200		High Machinability		-		-		-	
Maximum Slot Width	1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D	
Cutting depth, ap	1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D	
Cutting Width, ae	0.15 × D		0.15 × D		0.12 × D		0.10 × D		0.10 × D		0.10 × D		0.10 × D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
4	330	0.015	360	0.016	300	0.017	220	0.019	130	0.025	65	0.025	52	0.023
5		0.020		0.021		0.023		0.025		0.032		0.032		0.030
6		0.026		0.027		0.031		0.033		0.040		0.040		0.038
8		0.037		0.037		0.044		0.046		0.055		0.055		0.052
10		0.049		0.049		0.059		0.061		0.072		0.072		0.069
12		0.063		0.064		0.078		0.080		0.096		0.096		0.091
16		0.078		0.079		0.097		0.099		0.117		0.117		0.112
20		0.089		0.089		0.110		0.112		0.138		0.138		0.131